

Work Order ID 62685

Wednesday, October 06, 2010 10:51:21 AM

Page 1

Item ID: D2654-7

Accept

Revision ID:

Item Name: Web

Start Date: 10/6/2010 Start Qty: 4.00

Required Date: 10/15/2010 Req'd Qty: 4.00

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D2654

Rev E1

100

0.00



Skidtubes

Skidtubes

Memo

0.00

Skidtubes

1-Cut D2600-7 to length as per Dwg D2654
2-Drill pilot holes in web using drill jig DT 8018-7 as per Dwg D2654
3-Using the uni-bit, open holes to finish size as per Dwg D2654
4-Deburr holes and ends

> DP 10-10-6

110

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

DP 10-10-6

120

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

4 - BE 10-10-07

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 62685

Wednesday, October 06, 2010 10:51:21 AM



Page 2

Item ID: D2654-7

Accept



Setup Start



Revision ID:

Stop



Item Name: Web

Start Date: 10/6/2010 Start Qty: 4.00



Cust Item ID:

Required Date: 10/15/2010 Req'd Qty: 4.00



Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start



QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130



QC

Quality Control

QC3- Inspect Part Finish

0.00

Memo

0.00

4

-

BE 10-10-07

140



Packaging

Packaging

Identify as per dwg & Stock Location: LG

0.00

Memo

0.00

4

-

BE 10-10-07

150



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

10/10/07

mr
10-10-07

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NOTE: Date & initial all entries

Picklist Print

Wednesday, October 06, 2010 10:51:25 AM

Page 1

Work Order ID: 62685



Parent Item: D2654-7



Parent Item Name: Web



Start Date: 10/6/2010

Required Date: 10/15/2010

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:D□99.02.04□Fixed typo, Changed procedure□DM□
IPP Rev:e□06.04.05 Added level21 EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2600-7-140 		Manufactured	No			100	Each	46.0000	1	4			
													

EXT. "I BEAM" THICK

Location

LG

41591

Loc Qty

46

46

Loc Code

4A

10-10-6

W/O:		WORK ORDER CHANGES					
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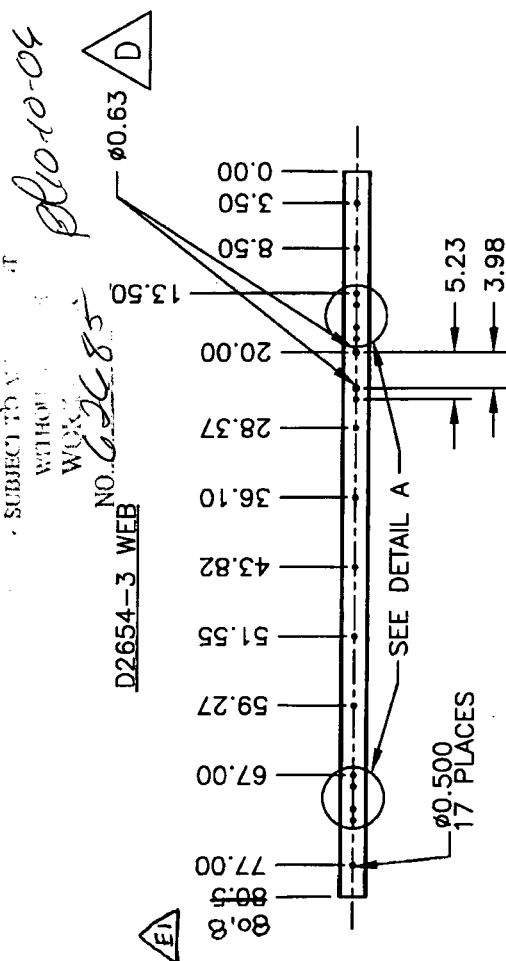
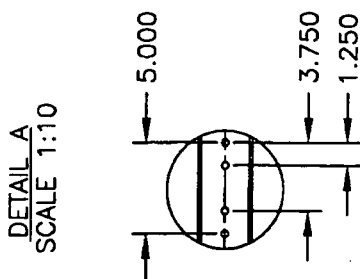
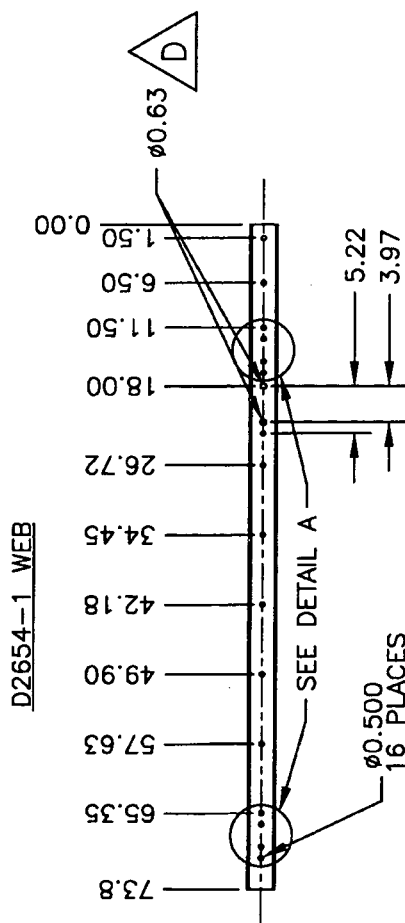
NOTE: Date & initial all entries

DART
DEO ATTACHED



DESIGN	CP	DRAWN BY	CP	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED	#	APPROVED	#	DRAWING NO. D2654	REV. E SHEET 1 OF 2
DATE	04.05.26			TITLE WEB	SCALE 1:20
A	97.03.25	NEW ISSUE			
B	97.06.26	ALTER HOLE PATRN., 0.500 WAS 0.438			
C	97.10.29	CHANGED HOLE PATTERN			
D	98.01.15	GHW HOLES CHANGED TO $\phi 0.63$			
E	04.05.26	CHANGE LENGTHS, REFORMAT			
E1	04.08.04	PER TOOLING; 80.8 WAS 80.5			

RELEASED
04.06.22



MAKE FROM D2600-5-108 EXTRUSION
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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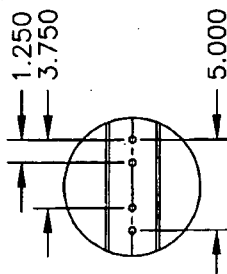


DESIGN <i>UP</i>	DRAWN BY <i>UP</i>	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2654	REV. E SHEET 2 OF 2
DATE 04.05.26		TITLE WEB	SCALE 1:20

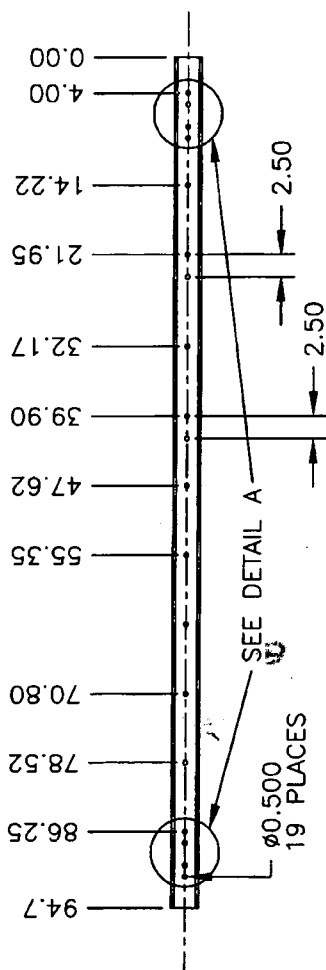
RELEASED
04.06.22

DEO ATTACHED

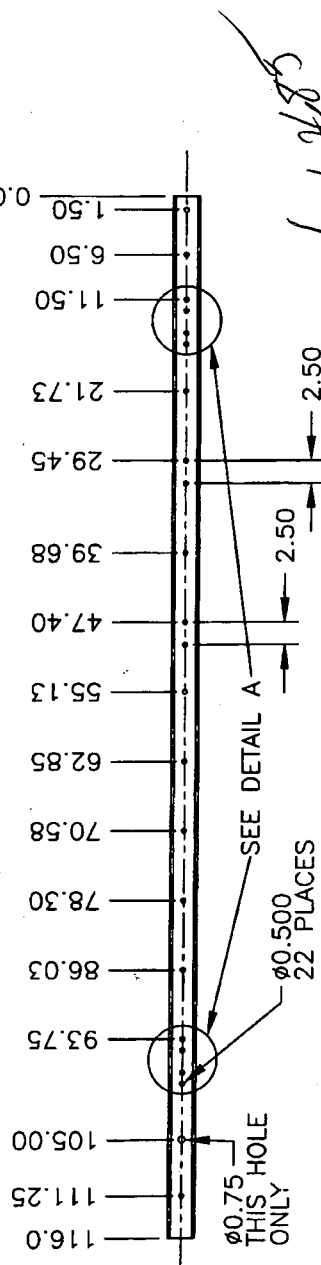
DETAIL A
SCALE 1:10



D2654-5 WEB



D2654-7 WEB



MAKE FROM D2600-7-125 EXTRUSION
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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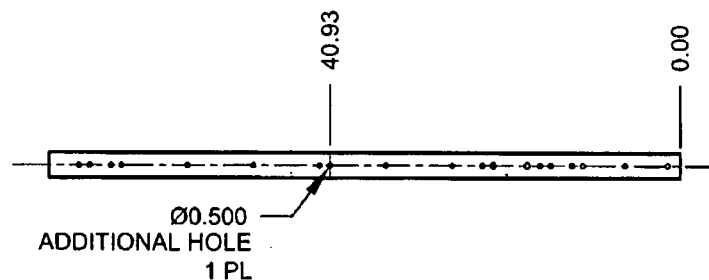
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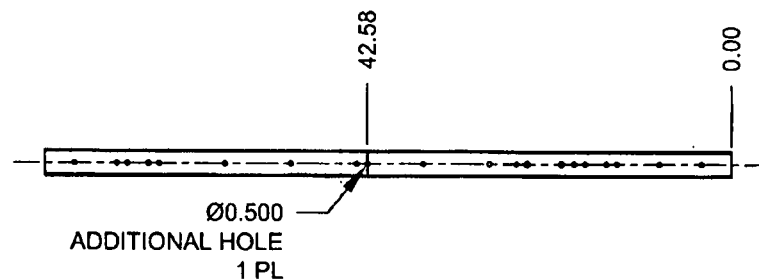
DRAWING NO. D2654	TITLE WEB	REV. E1	DART AEROSPACE USA, INC	D.E.O. NO. D2654-E-2	SHEET NO. SHEET 1 OF 1	SCALE NTS
DRAWN <i>LP</i>	CHECKED <i>PH</i>	MFG. APPR. <i>E</i>	APPROVED <i>W</i>	DE APPR. <i>#</i>		
DATE 09.03.11	DATE 09.03.11	DATE 09.04.03	DATE 09.04.03	DATE 09.04.03	DATE 09.04.03	

DRILL AN ADDITIONAL HOLE IN THE D2654-1 AND D2654-3 WEB AT THE LOCATION INDICATED:

RELEASED
09/04/03 *W*



D2654-1 WEB



D2654-3 WEB

W 62685

THE ADDITIONAL HOLE IS REQUIRED FOR COMPATIBILITY WITH D3804-041/-043 SKIDTUBE ASSEMBLIES. ALL OTHER INFORMATION REMAINS UNCHANGED.

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